

Date: Wednesday, 5/23/2007 3:24:05 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT		
Job Number	: 32459					
Estimate Number	: 10272					
P.O. Number	: N/A		Part Number	: D2562001		
This Issue	5/23/2007	S.O. No. : N/A	Drawing Number	: D2562 REV D		
Prsht Rev.	NC		Project Number	: N/A		
First Issue	N/A	Type : SMALL /MED FAB	Drawing Revision	: D		
Previous Run	30549		Material	: N/A		
Written By	:		Due Date	6/1/2007	Qty:	10
Checked & Approved By	:		Um:	Each		
Comment	: Est F 02.04.15 Added dwg Rev.B1 NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W
Comment: Qty.: 1.7920 f(s)/Unit Total : 17.9204 f(s) 35 : 84 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall Batch M104646		
2.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Punch to length as per Dwg D2562		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1.
Comment: SMALL/MED FAB RESOURCE 1- Bend end as per Dwg D2562 Angle "D" 2-Deburr		
4.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
5.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/06/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:24:06 PM
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Process Sheet

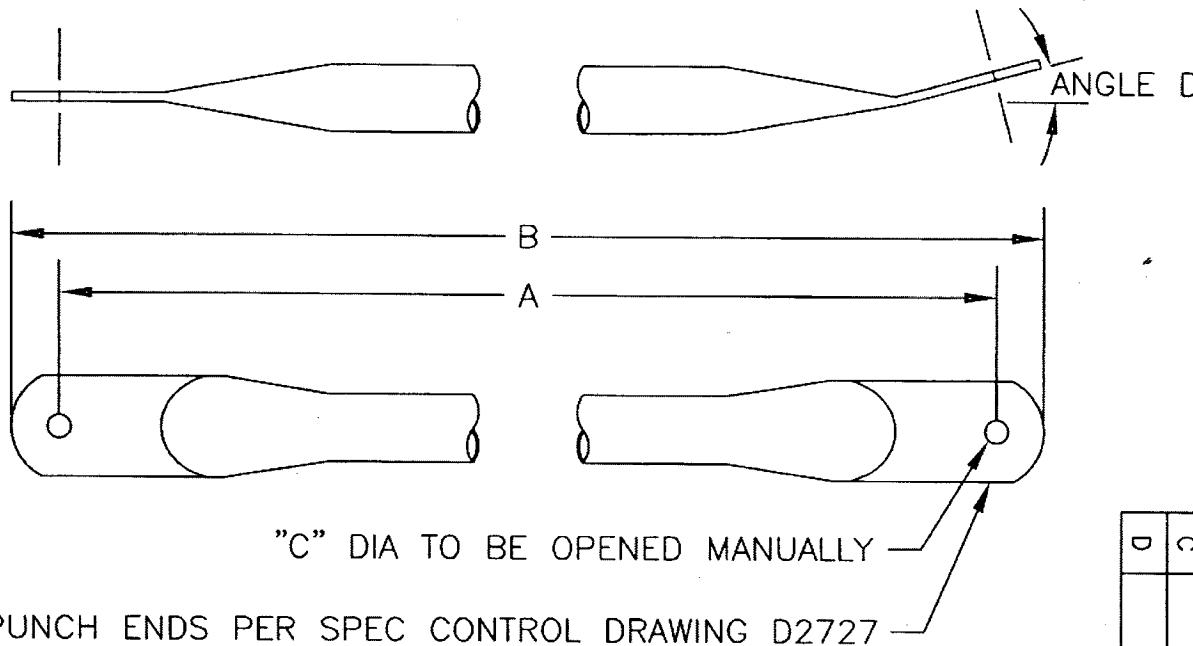
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: STRUT
Job Number: 32459		Part Number: D2562001
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  <i>PC7/8/27 (20)</i>
7.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: INSPECT POWDER COAT		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>S1253</i> 		
8.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>PC7/8/27 (20)</i>
Comment: FINAL INSPECTION/W/O RELEASE <i>1057/06/27</i>		
Job Completion 		<i>W 8/26/27</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	—	10
D2562-003	20.37	21.17	—	18
D2562-005	29.00	29.80	—	30
D2562-007	19.22	20.02	—	0
D2562-011	25.79	26.59	—	16
D2562-013	26.63	27.43	—	24

GENERAL NOTES

NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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05.05.27 *SH*

OBJEKT TO AMEND
WITHOUT NOTICE
WORK ORDER
NO. 32459

SHOP (OFF)
TRY TO

DRAWN BY		DART AEROSPACE LTD	
DESIGN	CP	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	W	APPROVED	W
DATE	05.05.18	DRAWING NO.	SHEET 1 OF 1
		D2562	REV. D
A	96.05.01	TITLE	SCALE
B	98.10.15	STRUT	1:2
C	02.06.05	UPDATED MATERIAL NOTE (TSR A603)	
D	05.05.18	ADD -005; ADD FINISH	
		ADD -007/-011/-013; UPDATE -005	